

Blue  
Work Order ID 72520

Thursday, July 28, 2011 8:49:29 AM

Page 1

Item ID: D3394-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 7/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3394 DEO

Rev B

155

0.00



SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK:

1 X D3394-043 ~~D66429~~ 62930

REMOVE GROMMETS AND DISCARD

SCUFF LIGHTLY

-PRIME B 117319

-DELFLEET BLUE B 118395

-DELFLEET CLEAR B 118053

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/5 11-08-04

11-08-05

# Work Order ID 72520

Thursday, July 28, 2011 8:49:29 AM



Page 2

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Small Fab	Small Fab	0.00				①			
Small Fab	Memo	0.00	SB	11/08/00					
Small Fab	Assemble as per Dwg D3394								
180  QC	QC5- Inspect part completeness to step on W/O	0.00				②			
Quality Control	Memo	0.00	8	11/08/00					
190  Packaging	Identify as per dwg & Stock Location: 420	0.00				11/08/00			DF
Packaging	Memo	0.00							

**Work Order ID 72520**

Thursday, July 28, 2011 8:49:29 AM



Page 3

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/09

PLC-08-8  
(U)

# Picklist Print

Thursday, July 28, 2011 8:49:26 AM

Page 1

Work Order ID: 72520

Parent Item: D3394-043

Parent Item Name: Lug Assembly



Start Date: 7/28/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3394-043		Manufactured	No				Each	88.0000		1			
Lug Assembly													

Location	Loc Qty	Loc Code
ST420	2	
71082	2	
ST475	86	
62930	12	
62976	28	
66429	33	
69180	13	

MS35489-93		Purchased	No				Each	197.0000		2			
GROMMET													

Location	Loc Qty	Loc Code
ST296	197	
116235	197	

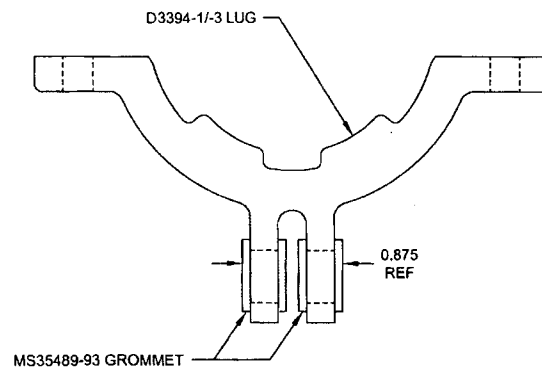
81 11-08-03

2 ✓

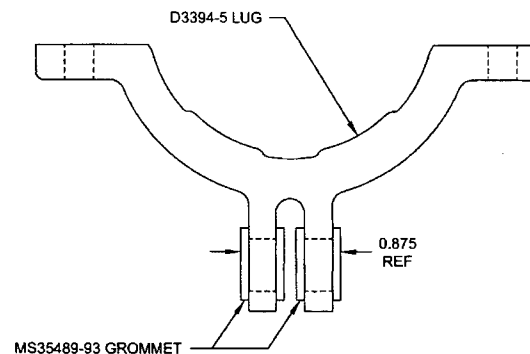
116235

116235

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

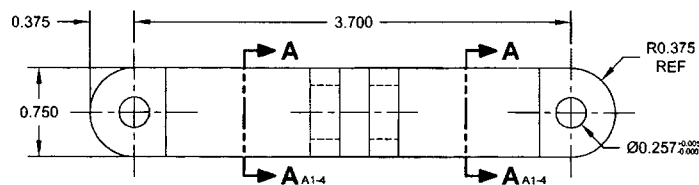
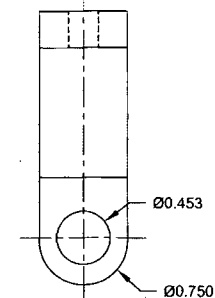
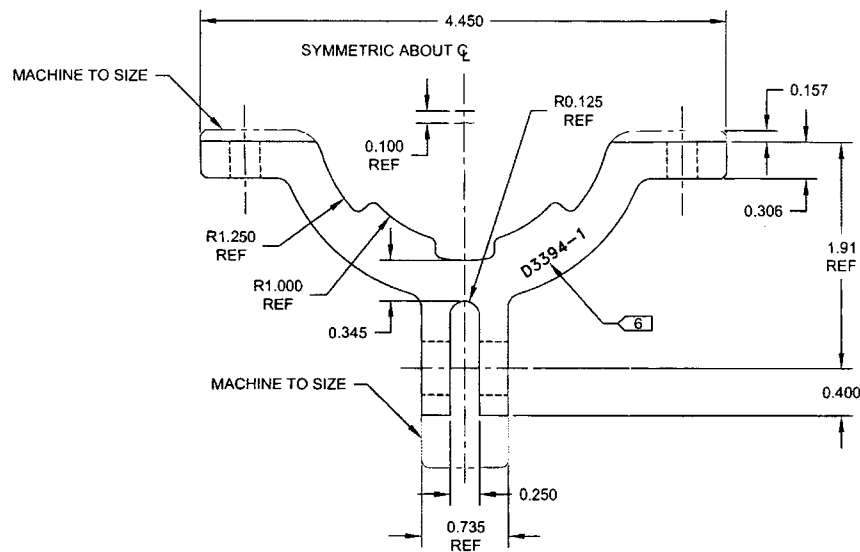
RELEASED  
09/04/25 JMD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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*W/O 92520*



D3394-1 LUG

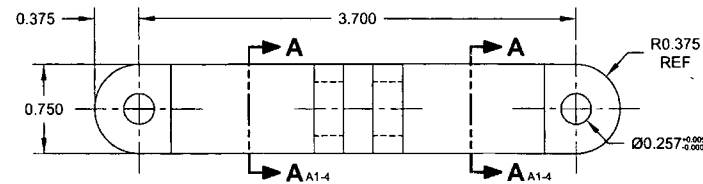
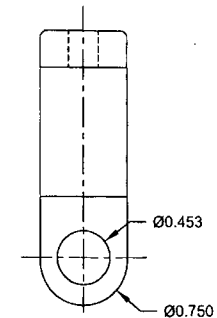
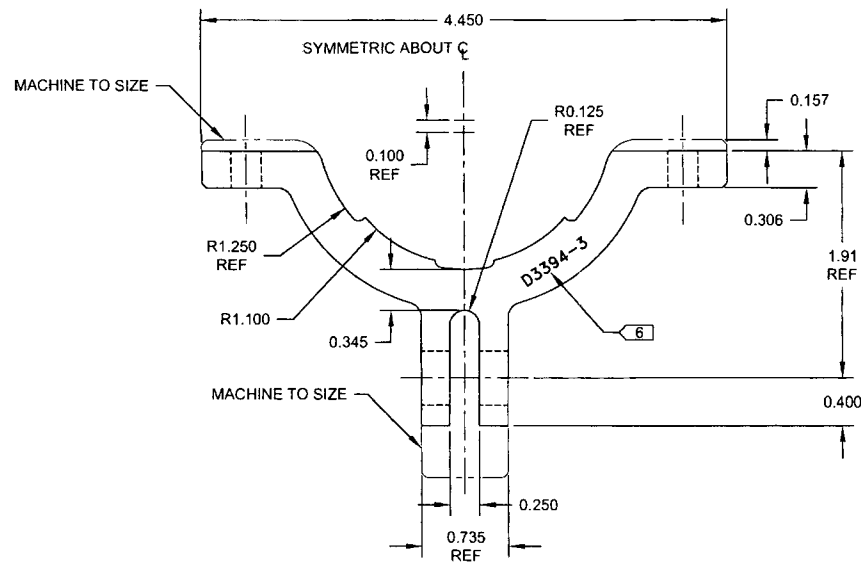
**NOTES:**

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED  
09/06/25

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 2 OF 4
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D3394-3 LUG



**NOTES:**

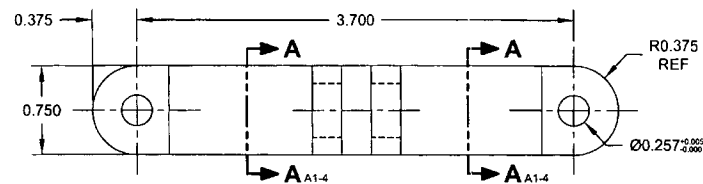
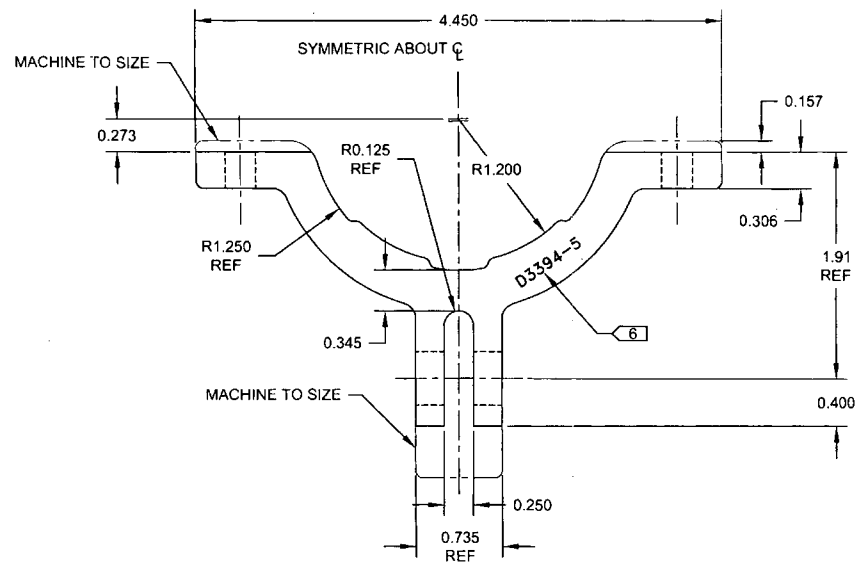
- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

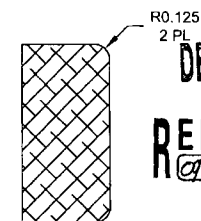
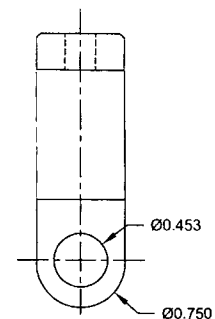
RELEASED  
09/04/25

22520

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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**D3394-5 LUG**





**SECTION A-A**  
B5-2  
B4-2  
B5-3  
B4-3  
B5-4  
B4-4

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

*72520*

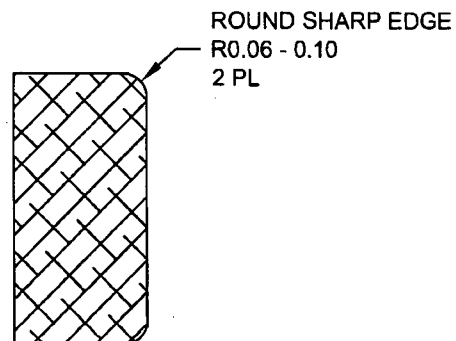
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04			

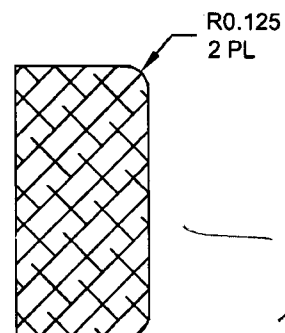
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

**RELEASED**  
2009-11-25  
*[Signature]*

72520

REASON: DRAFTING ERROR

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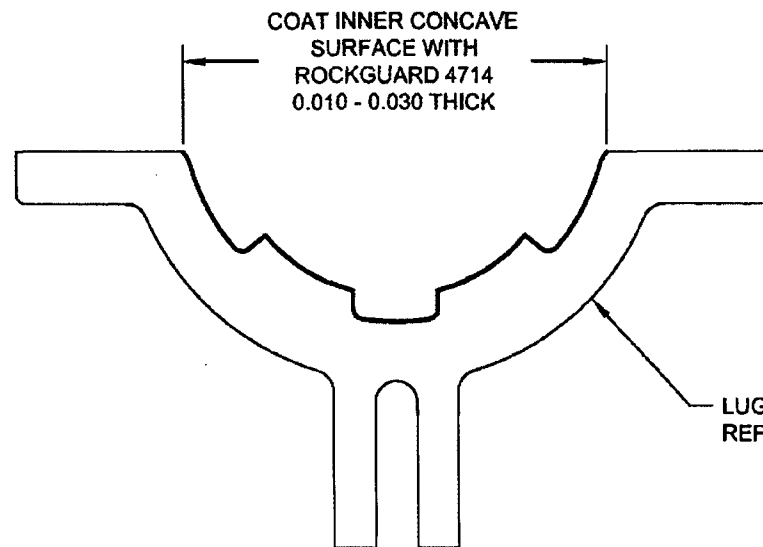
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DRAWN <i>Q</i>	CHECKED <i>Sc</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

**PURPOSE**

ADD D3394-xRG OPTION

**CHANGE**

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



D3394-1RG LUG (SHOWN)  
D3394-3RG/-5RG LUGS (SIMILAR)  
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

**RELEASED**  
2011-05-26  
*LM*

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